

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002139**Date Inspected:** 01-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck Panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 1

QA was present to perform Visual Testing (VT) of completed Partial Joint Penetration (PJP) welds joining U-Ribs to deck plate on deck panel DP-461-001. QA was unable to complete VT of the above mentioned deck panel before the end of this shift. All welds that were inspected appeared to exhibit some degree of undercut, lack of fusion, overlap, oversize and/or under fill. All of the completed (PJP) welds joining U-Rib to deck plate that have inspected on this panel do not appear to comply with the visual acceptance criteria specified in AWS D1.5 2002 and the contract documents.

**Production Monitoring Tests Macroetches**

QA Inspector performed a visual inspection of the only set of production monitoring tests (PMT) macro etch samples available, identified as DP-354-001. The PMT was welded this morning. All samples appeared to contain penetration greater than 80 percent. All the data from the review was recorded in a tracking log.

OBG bay 1

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## WELDING INSPECTION REPORT

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This QA inspector was present in OBG bay 1 to assist other CALTRANS OSM QA inspectors perform VT on deck panel DP-354-001. All welds that were inspected appeared to exhibit some degree of undercut, lack of fusion, overlap, oversize and/or under fill. All of the (PJP) welds joining U-Rib to deck plate that have inspected on this panel do not appear to comply with the visual acceptance criteria specified in AWS D1.5 2002 and the contract documents. QA completed a Caltrans QA visual verification weld inspection report for the OBG deck panel mentioned above. The report is on file in the Caltrans QA office.

### Summary of Conversations:

Only general conversations were held between QC inspectors and QA concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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